

Date: Monday, 5/26/2008 1:09:42 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 39492		
Estimate Number	: 13101		
P.O. Number	:	Part Number	: D36551
This Issue	: 5/26/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3655 REVA
First Issue	: / /	Project Number	: 00204
Previous Run	: 38503	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 5/27/2008
Checked & Approved By	: <u>JUO 08.5.26</u>	Qty:	1 Um: Each
Comment	: Ext. Rev. A 07/12/13 Est Rev:B 08-03-06 prototype DD verified by:EC Est Rev:C 08-04-07 revA DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET



Comment: Qty.: 3.7134 sf(s)/Unit Total : 3.7134 sf(s)
 GE PLASTICS LEXAN SHEET
 batch 105494 HB 8-5-26

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3655
 Dwg Rev: ^
 Prog Rev: ^

HB 8-5-26

②

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE
HB 8-5-26

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK
509/05/26 (x2)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: ST 241 A

AS 08/05/27 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/26/2008 1:09:42 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 39492

Part Number: D36551

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/27 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



cmf 08-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39492
Description: Panel		Part Number: D3655-1
Inspection Dwg: D3655	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.63	+/-0.030	2.63	X			
2.75	+/-0.030	2.74	X			
5.75	+/-0.030	5.75	X			
5.88	+/-0.030	5.885	X			
6.37	+/-0.030	6.37	X			
6.50	+/-0.030	6.50	X			
7.63	+/-0.030	7.626	X			
1.94	+/-0.030	1.945	X			
3.81	+/-0.030	3.865	X			
5.63	+/-0.030	5.635	X			
15.69	+/-0.030	15.69	X			
15.75	+/-0.030	15.75	X			
17.88	+/-0.030	17.88	X			
17.94	+/-0.030	17.94	X			
31.50	+/-0.030	31.50	X			
33.63	+/-0.030	33.63	X			
47.19	+/-0.030	47.19	X			
47.25	+/-0.030	47.25	X			
49.44	+/-0.030	49.44	X			
49.38	+/-0.030	49.375	X			
59.50	+/-0.030	59.50	X			
61.31	+/-0.030	61.31	X			
63.19	+/-0.030	63.19	X			
65.06	+/-0.030	65.06	X			
65.13	+/-0.030	65.13	X			
65.94	+/-0.030	65.94	X			
R9.50	+/-0.030	9.50	X			
R0.25	+/-0.030	.25	X			

Measured by: AB	Audited by: S	Prototype Approval:	N/A
Date: 8-5-26	Date: 08/05/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	DD

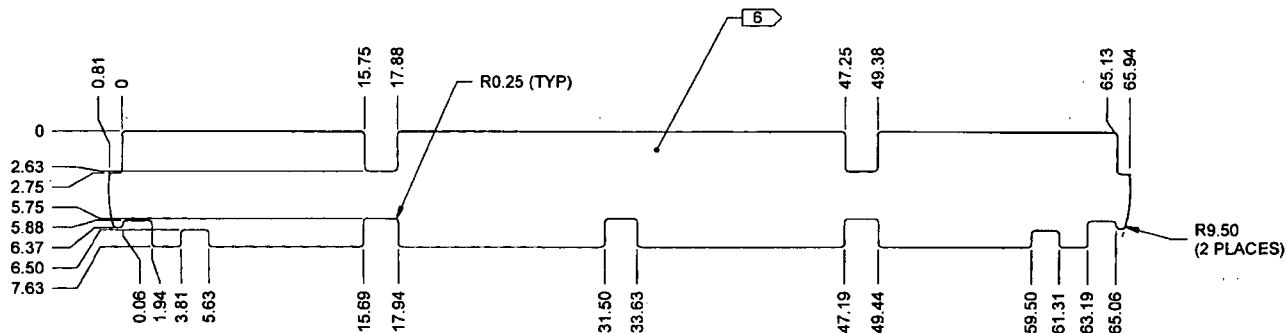
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3655-1 PANEL

Rev 08.05.26
 UNDER REVIEW
 08.03.03
 SEE PAGE 2.3

08.03.03 MP

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
 (REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

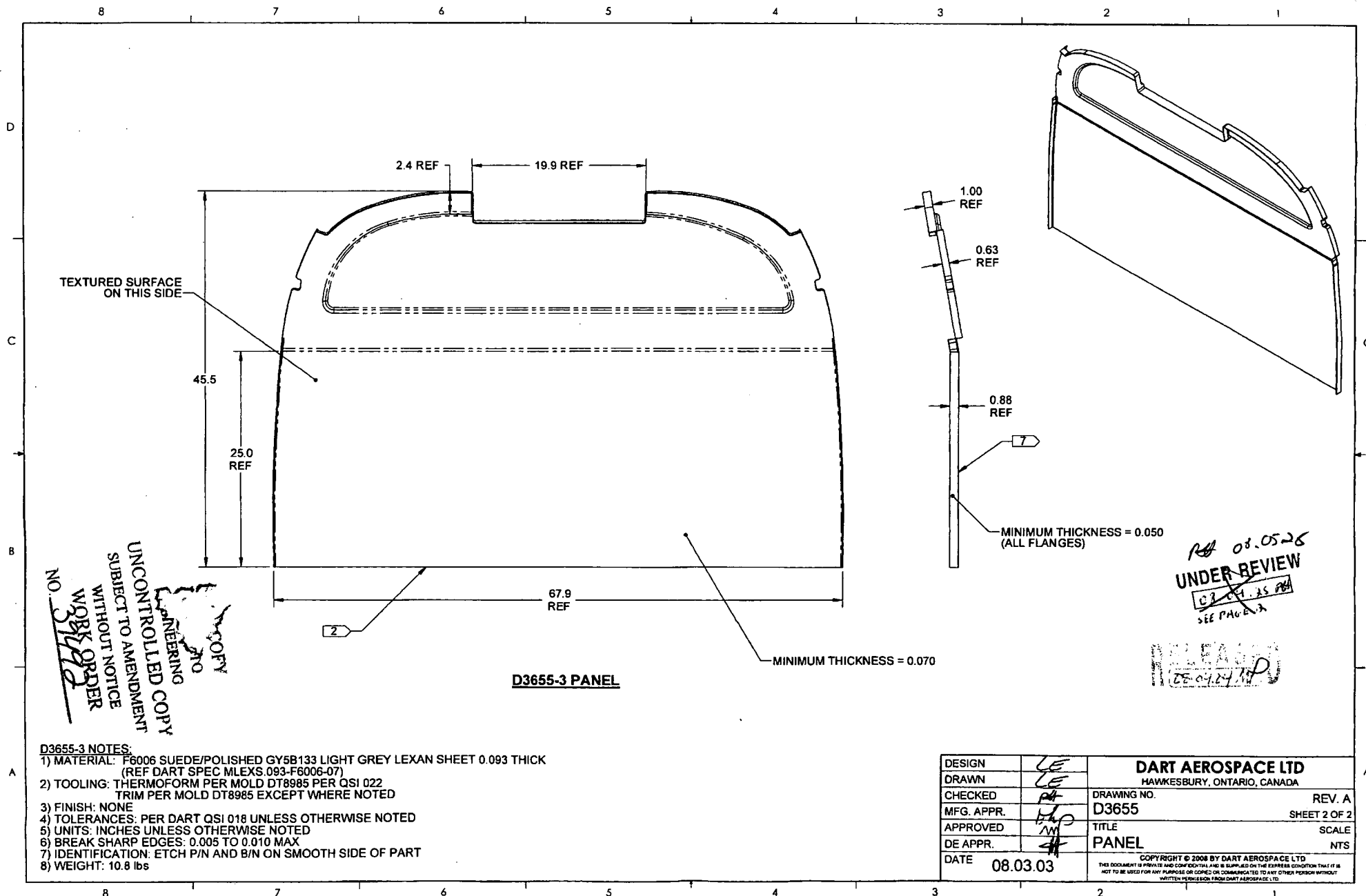
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	LE	08.03.03
DESIGN	LE		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	MP		
APPROVED	MP		
DE APPR.	MP		
DATE	08.03.03		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3655
 TITLE PANEL
 REV. A
 SHEET 1 OF 2
 SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD

SH 7 COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 38492



D3655-3 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8985 PER QSI 022 TRIM PER MOLD DT8985 EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 10.8 lbs